







Work Order ID 53497

November 6, 2009 11:00:23 AM


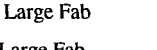


Page 1



Item ID: D3836-041 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Rib Assembly (Basket Lid, LH)
Start Date: 06/11/2009 Start Qty: 2.00  Cust Item ID:
Required Date: 13/11/2009 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan:  Date: 09-11-6 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

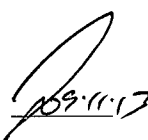
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3836	Rev A								


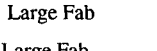
100  Large Fab 0.00
 Large Fab Memo 0.00
Large Fab 1- cut D3836-1 and D3836-3 rib as per dwg D3836-2- remove identification markings-3- deburr
SAD 09-11-13

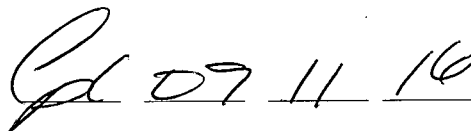
②

110  QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00
Quality Control

2



120  Large Fab 0.00
 Large Fab Memo 0.00
Large Fab 1- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836-2- weld D2327-3 spacer bushing as per dwg D3836-3 A/R ER316 S.S. Rod Batch: 4109213 -3- grind weld flush where indicated on dwg D



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Page 2

Item ID: D3836-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 06/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC9- Inspect visual per QS1004- Fusion Welds Memo	0.00 0.00							
						8D 09.11.16			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
						272			
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00							
						SAD			
						09-11-17			
						2			

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Page 3

Item ID: D3836-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 06/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/17 *[Signature]*
MF
09-11-17

Picklist Print

November 6, 2009 11:00:27 AM

Page 1

Work Order ID: 53497

Parent Item: D3836-041RevA

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 06/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2327-3RevD

Manufactured

No

100

Each

34.0000

2.0000



Spacer Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

34

44274

15

44365

9

51126

10

M304TS0.750W.065

Purchased

No

100

f

607.5273

3.7491



304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

600

113082

600

Main Warehouse

WA

7.5272947

112398

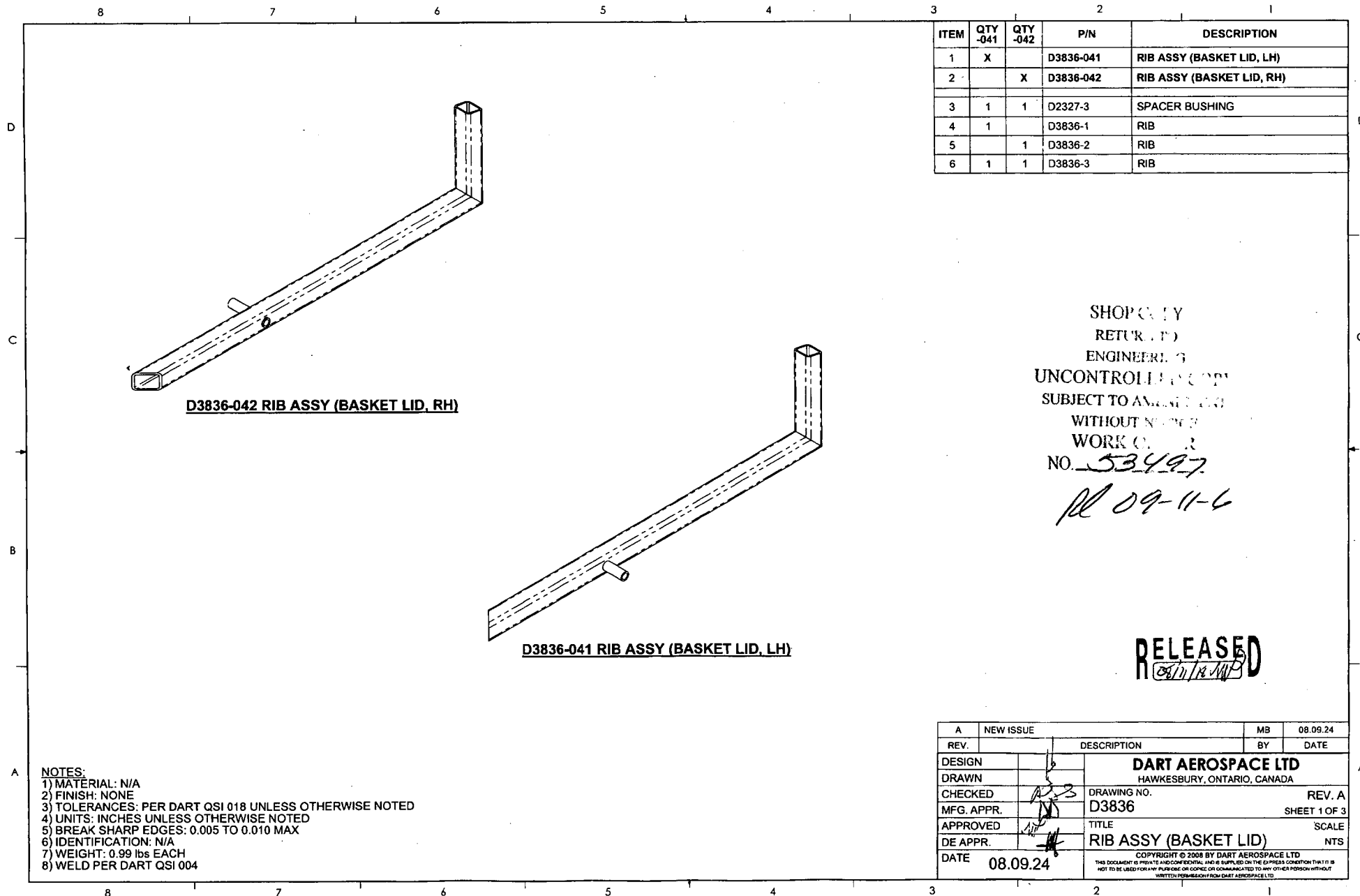
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09-11-16

(2) ✓

SAD 09-11-13

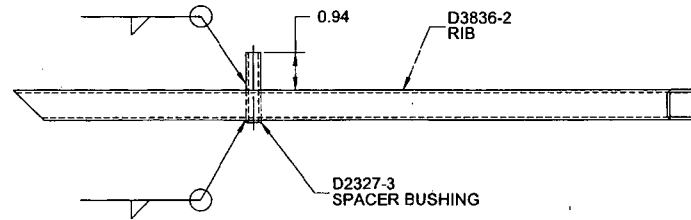
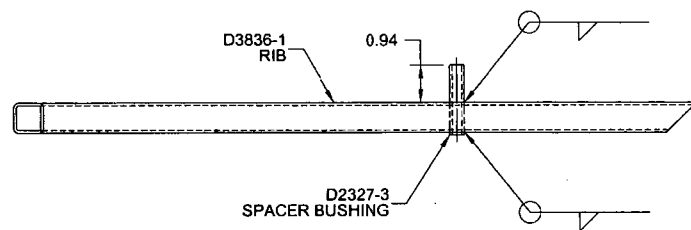
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8 7 6 5 4 3 2 1

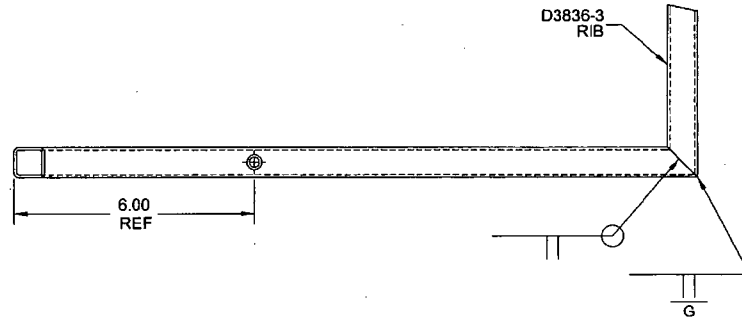
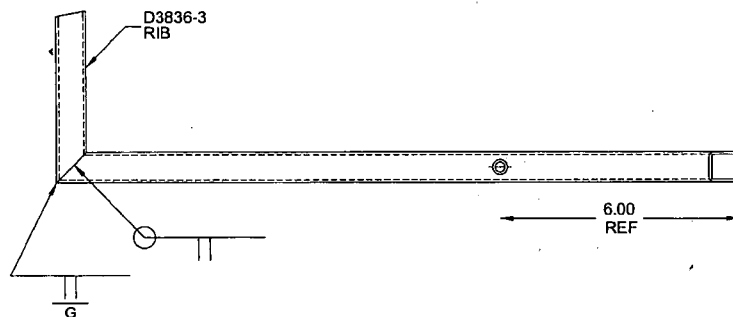
D

D



C

C



B

B

D3836-041 RIB ASSY (BASKET LID, LH)

D3836-042 RIB ASSY (BASKET LID, RH)

RELEASED
08/11/14

W10 53497

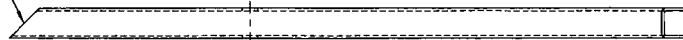
DESIGN		DART AEROSPACE LTD	REV. A
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	SHEET 2 OF 3
MFG. APPR.		D3836	
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
DATE	08.09.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

A

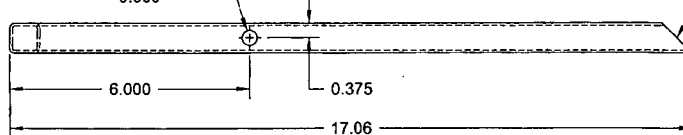
A

0.75 X 45°
CHAMFER

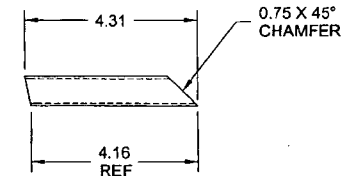


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER

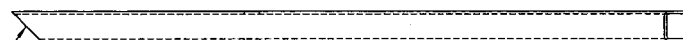


D3836-1 RIB



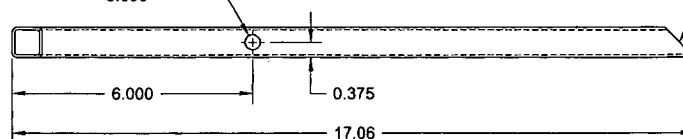
D3836-3 RIB

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CHAMFER

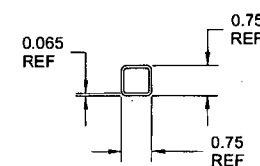


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER



D3836-2 RIB



**TYPICAL SECTION
VIEW**

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

RELEASED
08/11/18

11053497

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
DATE	08.09.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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